



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2731-7
Job Sheet 164245



Part No: D2731-7

Job Qty: 100 ea

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP D 00.05.19 Added inspect level 8, removed P/O powder coating EC IPP REV:E 13.06.25
OUTSOURCE METEC DD VERF:JFS

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D2731-7 Mounting Lug	DWG REV C IPP D 00.05.19 Added inspect level 8, removed P/O powder coating EC IPP REV:E 13.06.25 OUTSOURCE METEC DD VERF:JFS		0.000	
D2423 Lug Extrusion	DWG REV B1 IPP G 04.09.02 Part Number D2423-108 changed to D2423 KJ/JLM		0.000	
D2731-7P Lug	DWG REV B		0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	100 Ea	10/30/17	0.00	0.00	Start up containe	NOV 14 2017
160	QC	100 pcs	10/31/17	0.00	0.00	QC3	NOV 14 2017
170	Packaging	100 pcs	10/31/17	0.00	0.00	Packaging3	NOV 14 2017
180	QC21-SA	100 Ea	10/31/17	0.00	0.00	QC21	NOV 13 2017

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D2731-7 B164245		10,000 Ea (100 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2731-7 B164245	10,000	100	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	4.450Inches ± 0.010	4.460 4.440		
2	Mounting Lug	1.410Inches ± 0.030	1.440 1.380		
3	Mounting Lug	0.306Inches ± 0.010	0.316 0.296		
4	Mounting Lug	0.413Inches ± 0.010	0.423 0.403		
5	Mounting Lug	3.700Inches ± 0.005	3.705 3.695		
6	Mounting Lug	0.375Inches ± 0.010	0.385		

DART
AEROSPACE
S009944

**Job No: 164245**

Plex 10/11/17 12:54 PM Dart.Renwick.Jennifer

7	Mounting Lug	0.750Inches $\pm$ 0.010	0.760 0.740	0.365
8	Mounting Lug	0.257Inches $\pm$ 0.005	0.262 0.257	Diameter
9	Mounting Lug	0.100Inches $\pm$ 0.010	0.110 0.090	
10	Mounting Lug	45.000Degrees $\pm$ 0.000	45.000 45.000	
11	Mounting Lug	0.060Inches $\pm$ 0.040	0.100 0.060	Radius

Status: Stock
Part: D2731-7 B164245
Created: 9/30/17 11:51 AM DART.MICHAUD-FEBRILLE.VICTORIA
Serial No: S000076
Printed By: Goldston, Justin 10/2/17 10:44 AM

Work Order Summary

Thursday, September 28, 2017 1:47:16 PM

Page 1 of 1

Criteria : Work Order ID: 164245 Item ID: D2731-7 Product Family MACHINING
 Work Order Start Dates 8/4/2017 to 8/4/2017 11:59:59 PM Work Order Required Dates 9/25/2017 to 9/25/2017 11:59:59 PM
 All References
 Work Order Status Released

Work Order ID	164245	Required Qty	100.0000	Status Code	Released
Item ID	D2731-7	Accepted Qty	24.0000	Scrap Qty	0.0000
Item Name	Mounting Lug				
Current Acct Value	\$26.468				
Start Date	8/4/2017	Required Date	9/25/2017	Completed Date	
Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$1,237.435	\$51.560	\$13.494	(\$38.066)	-282.10%
Labor	\$35.479	\$1.478	\$0.987	(\$0.491)	-49.79%
Outplant	\$1,437.286	\$59.887	\$9.523	(\$50.364)	-528.85%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$88.560	\$3.690	\$2.463	(\$1.227)	-49.79%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$2,798.761	\$116.615	\$26.468	(\$90.148)	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
PO ID	PO Line Nbr	PO Receiver Date	Domestic Unit Price	PO Receipt Qty	Domestic Received Amt
D2423					
Lug Extrusion					
PO Rout Seq ID	PO Vendor ID	VC-ATE001			
D2731-7	11	8/23/2017 1:06:00 PM	\$14.4180	24.0000	\$346.032
Lug	2	9/26/2017 10:18:00 AM	\$14.3586	76.0000	\$1,091.254
			100.0000		8/17/2017
			100.0000		7/19/2017
				76.0000	\$913.140
				24.0000	\$277.416
Total Matl Amts:					\$1,237.435

Invoice Rout Seq ID		Invoice Vendor ID		VC-ATE001	
Invoice ID	Invoice Line Nbr	Invoice Date	Invoice Unit Price	Invoice Qty	Invoice Amt
898821	11	9/1/2017 9:47:49 AM	14.3586	24.0000	\$344.606

Work Center		HandFinish										
Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
BOUD01												
	8/3/2017											
140			0.00	0.00	1.16	0.58	2.00	\$0.000	\$12.692	\$31.681	\$0.000	\$44.374
LECO02												
	8/22/2017											
140			0.00	0.00	3.13	1.04	3.00	\$0.000	\$22.787	\$56.879	\$0.000	\$79.666
Total:			0.00	0.00	4.30	1.63	5.00	\$0.000	\$35.479	\$88.560	\$0.000	\$124.040

Thursday, September 28, 2017 1:47:16 PM

Work Order Summary

Page 1 of 1

SPL17-2

Work Order ID 164245

Monday, July 17, 2017 2:28:42 PM

164245

BLUE

Item ID: D2731-7 Accept 76 *N900040100* Setup Start *NS1*
 Revision ID: JUL 18 2017 Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 8/4/2017 Start Qty: 100.00 *100*
 Required Date: 9/25/2017 Req'd Qty: 100.00 *100*
 Reference: DAS
 Cust Item ID: 13
 Customer: 9-89

Approvals: Process Plan: 21 Date: JUL 17 2017 Tooling: SPC (Y/N):
 QC: Date: Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2731	Rev C								DAS 13 9-89
110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	18,000.00							
Outsource process - Machining	Issue P/O to Metec: <u>37085</u>								
	Machine as per dwg								
	C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	2.00							
Packaging	ENSURE C OF C IS ATTACH.								
130	QC6- All purchased or subcontracted products	0.00							
130									
QC	Memo	0.00							
Quality Control									

76
100

JUL 17 2017

76

DAS
6
9-89
AUG 17 2017

89-6
9
DAS

76

AUG 18 2017

DAS
38
9-89

Work Order ID 164245

Monday, July 17, 2017 2:28:42 PM

164245

Page 2

Item ID: D2731-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 8/4/2017 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
Hand Finish	Memo	2.01				76	0		2017-08-22 SSC BEB
Hand Finishing									
145		0.00							
145									
Spray Paint	Memo	0.00				76			SEP 20 2017
Spray Painting	PRIME B DEFLECT BLUE B DEFLECT CLEAR B								
155	QC3- Inspect Part Finish	0.00							
155									
QC	Memo	0.00				Flex		DAS 26 9-89	SEP 28 2017
Quality Control									

PO 37816
→
Received

Flex SPR 9-24

Work Order ID 164245

Monday, July 17, 2017 2:28:42 PM

164245

Page 3

Item ID: D2731-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 8/4/2017 Start Qty: 100.00 ***100*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 100.00 ***100*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST520</u>	0.00							
170									
Packaging	Memo	1.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	10.00							
Quality Control									

Handwritten notes and stamps:
76x. (circled)
DAS 26 SEP 28 2017
9-89
DAS 41 NOV 14 2017
9-89

Picklist Print

Monday, July 17, 2017 2:28:48 PM

Page 1

Work Order ID: 164245

164245

Parent Item: D2731-7

D2731-7

Parent Item Name: Mounting Lug

Start Date: 8/4/2017

Required Date: 9/25/2017

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D00.05.19Added inspect level 8, removed P/O powder
coatingEC IPP REV:E 13.06.25
OUTSOURCE METEC DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-7P		Purchased	No			100	Each	0.0000	1	100			
D2731-7P													
Lug													
D2423		Manufactured	No			110	f	513.7539	0.0683	7.189474			
D2423													
Lug Extrusion													

Location

Loc Qty

Loc Code

Metec

513.7538737

115229

60.356

127892

83.2745647

148835

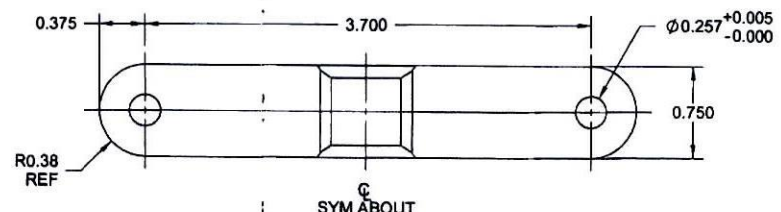
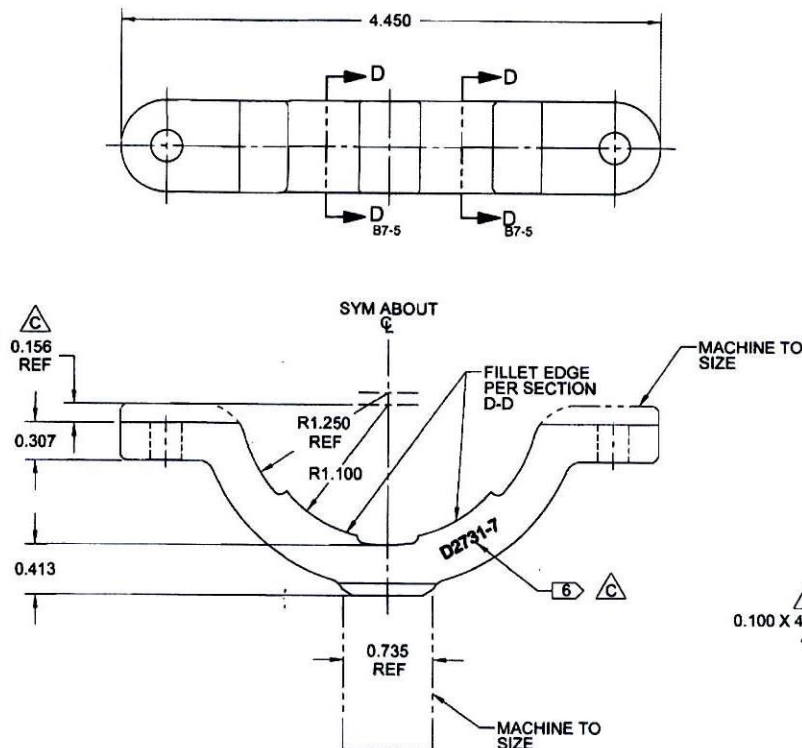
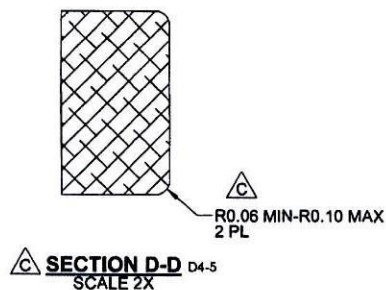
34.123309

160522

336

DAS 6 AUG 17 2017
9-00
DAS 13 9-00
JUL 17 2017

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164245 M.C.
17-0777



D2731-7 MOUNTING LUG

DEO ATTACHED
RELEASED
09/06/25 MP

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21975
Date: Aug 15, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 37085	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Aug 15, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-7 Lug, unpainted	Each	100	76 AUG 17 2017 50	
D3394-3 Lug, unpainted	Each	60		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37085**

Purchase Order Date 7/17/2017

PO Print Date 7/17/2017

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Contact Name
Vendor Phone 613 678 3957

Ship To Contact
Ship To Phone
Ship Via: Dart Truck
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extens Pr
1	D2731-7P AS PER DWG D2731 REV. C B164245 NO PAINT REQUIRED	Lug ✓	8/16/2017 Yes 8/16/2017		100.00 Each	\$15.00	\$1,500
Line Total:							\$1,500
2	D3394-3P AS PER DWG D3394 REV. B B162246 NO PAINT REQUIRED	Lug ✓	8/16/2017 Yes 8/16/2017		60.00 Each	\$16.10	\$966
Line Total:							\$966

Note:

7/17/2017

DAG
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37816

Purchase Order Date 9/20/2017

PO Print Date 9/20/2017

Page Number 1 of 2

Order From :

ATELIER DEBOSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

VC-ATE001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name

Vendor Phone 819 242 5633

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	164227 as per Dwg D2651 Rev B B164227 Prime and paint Delflect Blue	D2651-1BL Plug	9/22/2017 Yes 9/22/2017		500.00	\$18.00	\$9,000.00
Line Total:							\$9,000.00
2	164245 As per Dwg D2731 Rev C B164245 Prime and spray paint Delflect Blue	D2731-7 Mounting Lug	9/22/2017 No 9/22/2017		76.00	\$18.00	\$1,368.00
Line Total:							\$1,368.00

8879-27

Note:

9/20/2017